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PRODUCT INFORMATION

PRODUCT DESCRIPTION: **AC-78/D2744 ALCHEMETAL ANTI-CORROSIVE**
PRODUCT CODE: D2744

GENERAL INFORMATION:
The primary end use for this sample is: ANTI-CORROSIVE, CONDUCTIVE COATING

PRODUCT SPECIFICATIONS:

SOLIDS, theoretical:	66.45 +/- 2.0% by wt.,	29.33 +/- 2.0% by vol.
DENSITY, theoretical:	17.63 +/- 0.2 lb/gal,	2.116 +/- 0.020 Kg/liter
COVERAGE, theoretical:	470.55 sq.ft./gal.@ 1 mil,	5.47 sq.m./Kg.@ 25 microns

VISCOSITY, as shipped: 30 - 40 SECONDS ZAHN #3 (S90) at 77°F (25°C)

TYPICAL PROPERTIES:

FLASH POINT:	180°F,	82°C
VOLATILE ORGANIC CMPDS:	5.90 lb./gal.,	708.00 grams/liter

PREPARATION OF PARTS FOR COATING:
Parts must be free of dirt, oil and other soils to achieve good adhesion and defect-free coatings. The following are the recommended substrates and substrate preparations used with this coating:
SUBSTRATES: MOST METALS, SOME PLASTICS AND CERAMICS
PREPARATION: THOROUGH DEGREASE, GRIT BLAST PREFFERED FOR BEST ADHESION

PRIMERS OR BASECOATS: NOT REQUIRED; XYLAN 4090 PRIMER OPTIONAL

PREPARATION OF COATING MATERIAL:
Mix containers thoroughly by shaking or stirring until any solid material on the bottom has been eliminated. Best results are obtained when the coating temperature is 65-90°F (18-32°C). Adjust viscosity, if necessary, using the recommended thinner and an accurate Zahn Viscosity Cup. Other viscosity cups may also be used. Add thinner in increments of 2% until proper viscosity is achieved. Low viscosity produces runs and sags and low film thickness. High viscosity produces poor sprayability and uneven appearance. Any dried coating or dirt may be removed by passing the coating through a 100-200 micron filter.

APPLICATION VISCOSITY: 20-30 SEC #3 ZAHN

VISCOSITY ADJUSTMENT: SUPPLIED SOLVENT BLEND (SOLVENT 27)

OTHER INFORMATION: MIX WELL UNDER HIGH SPEED MIXER UNTIL ALL SOLID MATERIALS ARE INCORPORATED

PRODUCT INFORMATION

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APPLICATION INFORMATION:
This product is designed primarily for spray application. Consult with a Whitford representative if other types of application are being considered. Use an air spray gun with a siphon cup or pressure pot. Select a fluid nozzle and air cap that meet application needs. The Whitford Laboratory uses a Binks Model 2001 gun with a #66S fluid nozzle and a #66SD air cap. The air supply line must be equipped with traps to remove water and oil. Drain and service traps frequently.

Apply the dry film thickness as specified. The proper amount of coating should be achieved with two or three passes of the spray gun across the work piece. Apply the coating to a uniform, full wet appearance.

DRY FILM THICKNESS: 1.0 - 1.6 MIL PER COAT

CLEAN UP SOLVENT: NMP/XYLENE - 2:1 RATIO

CURING THE COATING:
In order to completely cure the coating, the SUBSTRATE TEMPERATURE must remain at the specified temperature for the entire bake schedule.

FLASH OR AIR DRY: 5 MINUTES AT 200°F (94°C)

BAKE SCHEDULE: 30 MINUTES AT 428°F (220°C) PART METAL TEMPERATURE; CURE TEMPERATURE MAY BE DECREASED WITH LONGER DWELL TIME.

COATING SPECIFICATIONS:
Evaluate the coating according to the following specifications:

PENCIL HARDNESS: 4H GLOSS: DEAD FLAT

CURE TEST: APPLY ONE DROP OF NMP TO COATING SURFACE AND ALLOW TO STAND 10 MINUTES. FULL CURE ACHIEVED WHEN NMP HAS NO AFFECT. CONDUSTIVE CHARACTERISTICS CAN BE OBTAINED EVEN IF FULL CURE NOT DEVELOPED.

ADHESION: X-HATCH AND TAPE PULL=NO LOSS

OTHER: USE TEMP 260°C CONTINUOUS; 315°C INTERMITTENT

HANDLING & STORAGE:
Keep containers tightly closed when not in use. Store between 40 to 95°F (4 to 35°C). Avoid breathing fumes during application or curing. Wash hands thoroughly before smoking or eating. Wear appropriate protective equipment while handling.

SHELF LIFE: 6 MONTHS (MIX 30-60 MINUTES MONTHLY TO MAINTAIN QUALITY)

PREPARED BY: KLM DATE: 23 JANUARY 2004